

Work Order ID 95665

95665

Page 1

Wednesday, January 16, 2013 11:04:16 AM

Item ID: D2370

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Assembly

Start Date: 1/16/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/1/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *WUF*

Date: *12-1-16*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2370

Rev C

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue p/o: *13045* Order: Model 12-2A undrilled with grey pad & black belts
Supplier: Ferno Aviation Letter of compliance required

CZ 13/01/16 *(4)*

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Insure that letter of compliance is attached to w/o

13/3/01 *(4)*

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

1334

4

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D23702-Drill 0.191" holes as per Dwg D23703-
Replace lose rivets with screw per dwg D2370 Apply locktite3-Deburr *N/AV*

13/13/05

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS 16 13/3/6

Pto last page →

150

Identify as per dwg & Stock Location: *57/57*

0.00

150

Packaging

Memo

0.00

Packaging

13/3/17 (4)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AK Date: 13/03/11QA Closed: AK Date: 13/3/8

Work Order: <u>95665</u> Part No. <u>D 2370</u> NCR No. <u>13-2386</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input checked="" type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	13/3/6	130	1	Qty (1) pip pin hole was misdrilled. Pilot hole drilled overlapping correct hole.	DAS 12 9-89 13/3/5	Weld and re-drill hole. M122324 Hole is not under stress. on neutral axis. Near end of stretcher where bending stresses are not high. Acceptable.	LH 13-03-05	DAS 09 9-89 13-03-06	DAS 16 9-89 13/3/6
Equip/Tooling <input type="checkbox"/>									
Operator <input checked="" type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 95665***95665***

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Wednesday, January 16, 2013 11:04:16 AM

Item ID: D2370

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Litter Assembly

Stop ***NS2***

Start Date: 1/16/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/1/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 13-03-07

1/13-03-1

Picklist Print

Wednesday, January 16, 2013 11:04:15 A

Page 1

Work Order ID: 95665

Parent Item: D2370

Parent Item Name: Litter Assembly

Start Date: 1/16/2013

Required Date: 2/1/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP D 01.10.10Changed D2484 nut for D3015-1 SM
IPP E 06.12.12 ecn 888 ec

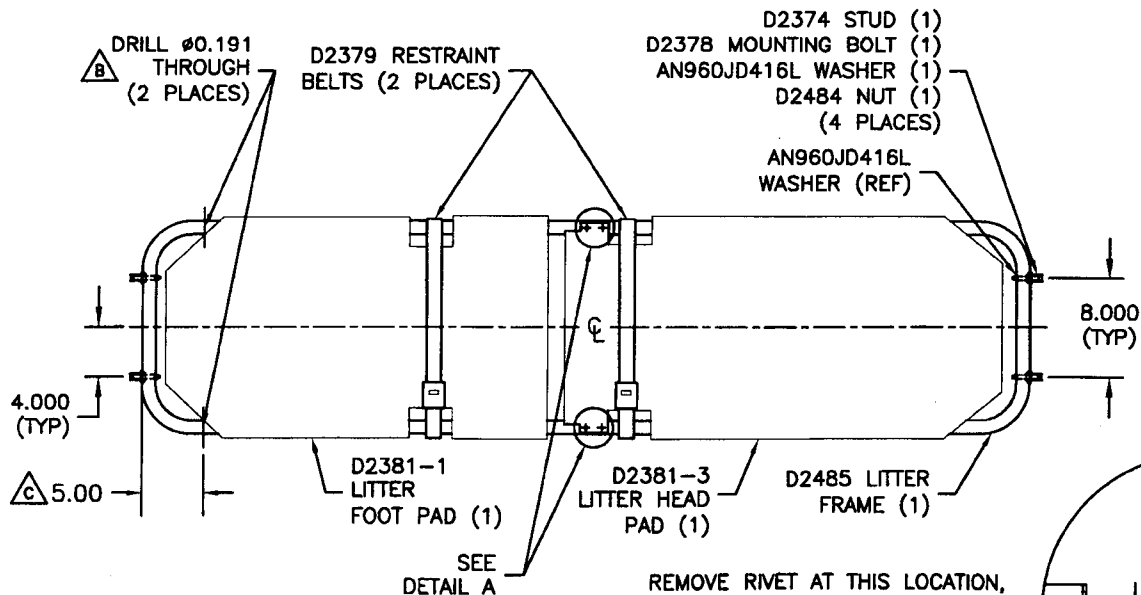
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416L Washer	NAS1149D0416J	Purchased	No			130	Each	6.0000	4	16		1/13/03/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		6							
					110153	6							
D2370P Litter Assembly		Purchased	No			130	Each	0.0000	1	4		1/13/03/05	
D2374 Stud		Manufactured	No			130	Each	10.0000	4	16		1/13/03/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		10							
					88302	10							
D2378 Bolt		Manufactured	No			130	Each	50.0000	4	16		1/13/03/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		50							
					79476	4							
					89339	21							
					94747	25							
D3015-1 Lock Nut		Manufactured	No			130	Each	264.0000	4	16		1/13/03/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST023		264							
					14710	264							
MS27039-4-06 Screw		Purchased	No			110	Each	131.0000	2	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST307		131							
					123355	131							

DART

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2370	REV. C SHEET 1 OF 1
DATE 06.11.21		TITLE LITTER ASSEMBLY	SCALE NTS
A	95.02.20	NEW ISSUE	
B	98.06.09	ADDED Ø0.191 HOLES	
C	06.11.21	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES, AND 5.00 WAS 5.34	

RELEASED**06 12 05**

D2370	Part No.	Description
X	D2370	LITTER ASSEMBLY
4	D2374	STUD
4	D2378	MOUNTING BOLT
2	D2379	RESTRAINT BELTS
1	D2381-1	LITTER PAD
1	D2381-3	LITTER PAD
4	D2484	NUT (OR D3015-1) \triangle C
1	D2485	LITTER FRAME
4	AN960JD416L	WASHER
2	MS27039-4-06	SCREW \triangle C

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE STATED
- 3) FINISH: NONE
- 4) TORQUE SCREWS TO 15-25 in-lb
- 5) REMOVE ALL SHARP EDGES 0.010 TO 0.020 MAX

REMOVE RIVET AT THIS LOCATION,
ENLARGE HOLES TO
Ø0.213 (#3 DRILL) x 0.75 DEEP,
TAP HOLE 1/4-28 UNF x 0.50 DEEP,
SECURE PARTS WITH
 \triangle C MS27039-4-06 SCREW (1)
(2 PLACES)

DETAIL A
RIVET REPLACEMENT**Copyright © 1995 by DART AEROSPACE LTD**

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FERNO Aviation, INC.

735-B Branch Drive
Alpharetta, GA 30004
Office 770.521.1005 Fax 770.521.0910
<http://aviation.ferno.com>

Commercial Invoice

DATE	INVOICE NO.
2/26/2013	12865

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Accounts Payable

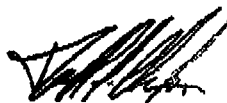
SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO18845

PO NO.	TERMS	REP	SHIP DATE	SHIP VIA		FOB
PO 8845	Net 30	KD	2/26/2013	Fed-X Ground		Alpharetta
ITEM	DESCRIPTION			QTY	UNIT PRICE	AMOUNT
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints S/N: 13N256565, 13N256566, 13N256567, 13N256568, & 13N256560 (HS Code 8803.30.00.00) Order shipped using Fed-X Acct. #1517-9324-0. Fed-X Tracking #			5	1,491.00	7,455.00
Thank you for your order!					Total	\$7,455.00

FERNO Aviation, INC.735B Branch Drive
Alpharetta, GA 30004Telephone: 770.521.1005
Fax: 770.521.0910**CERTIFICATE OF CONFORMANCE****Date:** 02/26/2013**Customer:** Dart Aerospace, Inc.**P.O. Number:** PO18845

<u>Part Number</u>	<u>Description</u>	<u>Serial Number</u>
Model 12-2A	Aeromedical Stretcher w/Orange FAA	13N256568
	Approved Cover and Black FAA Approved	13N256567
	Patient Restraints	13N256566
		13N256565
		13N256560

We hereby certify that all items in the above shipment have been produced, inspected and found to be in compliance with applicable drawings, customer specifications, and purchase order requirements including the flammability requirements of the Department of Transportation Federal Aviation Administration FAR 25.853 appendix F Part I(a)(1)(ii). All documents utilized were the latest revision in effect on the date of this order, or as specified by buyer.

Robert C. Chinn
QA, Ferno Aviation



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18845**

Purchase Order Date 1/16/13

PO Print Date 1/23/13

Page Number 1 of 1

Order From :

VU-FER001

FERNO AVIATION INC.
735-B BRANCH DR.
ALPHARETTA, GA 30004
US

Contact Name

Vendor Phone

770 521 1005

Vendor Fax

770 521 0910

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

FAXED
01/30/13

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2370P	Litter Assembly	3/08/13 Yes	4.00 Each	FedEx PI collect	\$1,491.0000	\$5,964.00

Special Inst: AS PER DWG D2370 REV. C
B95665

MODEL 12-2A UNDRILLED WITH GREY
& BLACK BELT

2	D2370P	Litter Assembly	1/22/13 Yes	1.00 Each	FedEx PI collect	\$1,491.0000	\$1,491.00
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Special Inst: AS PER DWG D2370 REV. C
B96124

MODEL 12-2A UNDRILLED WITH GREY
& BLACK BELT

PO Total: \$7,455.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 4

Change Date: 1/23/13

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO